



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT18560-1
Job Sheet 170254



Part No: RBT18560-1

Job Qty: 6 ea

Part Name: Puller



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/12/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG.RBT18560 Rev.4 IPP Rev A 17.11.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		1/30/18	0.00	0.00	Start Up Machining-4		
100	Bandsaw	6 pcs		1/30/18	0.00	0.60	Bandsaw1		
120	Mori Seiki	6 pcs		1/31/18	0.00	12.00	MORI SL2500Y		
130	QC	6 pcs		1/31/18	0.00	0.00	QC2 Machining-3		
150	QC	6 pcs		1/31/18	0.00	0.00	QC8 Machining-3		
160	Small Fab	6 pcs		1/31/18	0.00	0.00			
180	QC	6 pcs		1/31/18	0.00	0.00			
190	Outsource	6 pcs		1/31/18	0.00	0.00	Outsource1	39181	cx MAR 16 2018
200	Outsource	6 pcs		1/31/18	0.00	0.00	Outsource12		AT 18/03/27
210	Packaging	6 pcs		1/31/18	0.00	0.00	Packaging2		AT 18/03/27
220	QC	6 pcs		1/31/18	0.00	0.00	QC6		11 MAR 28 2018
230	Packaging	6 pcs		1/31/18	0.00	0.00	Packaging3		9-89
260	QC21-SA	6 Ea		1/31/18	0.00	0.00			DAS APR 02 2018

Part Op 100 - Cut blanks to 3.125"

Descriptions: 120 - 1-Machine as per folio FB 727 FOLIO REV: _____ DWG REV: _____ 9-2-Debur

160 - DEBUR, SEPARATE SLOTS

190 - 1--Issue P/O to Metcore ; P/O 39181 RC 45-52 ***Heat treat with expander fixture installed*** 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech

200 - -Issue P/O to Groupe Altech; PO 39337 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

MAR 23 2018

Job Allocations

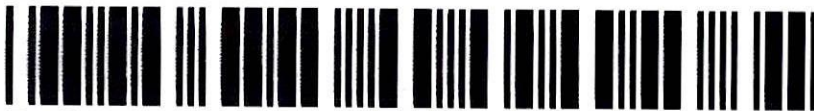
Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MT-H13-R2.500	2	6	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S036963

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Puller

PART NO: RBT18560 - 1

Original Serial #: S036963

Revision:

Operation: Start up Operation 01/30/18

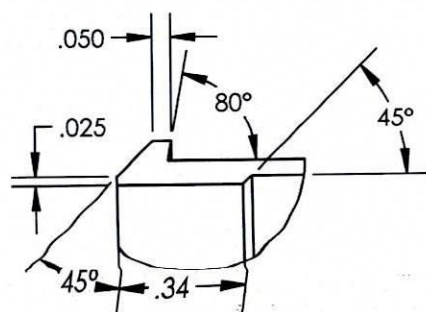
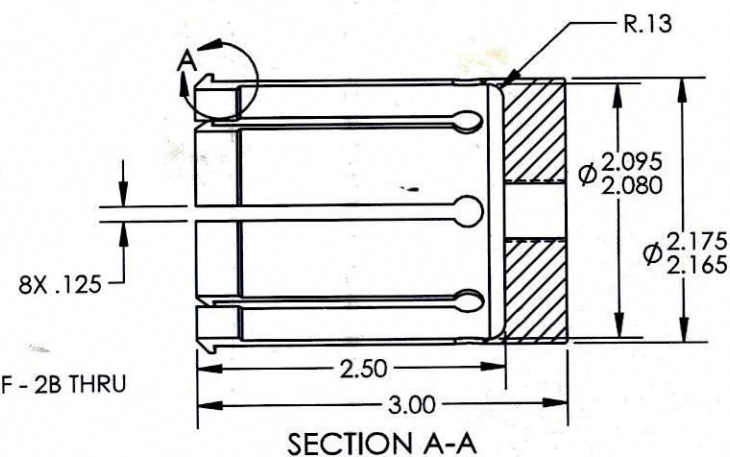
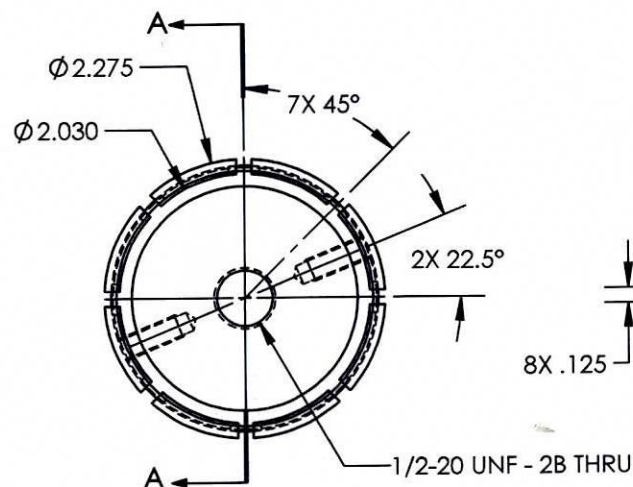
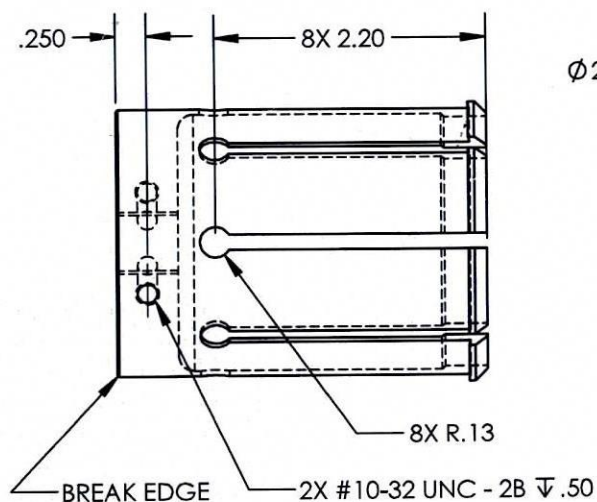
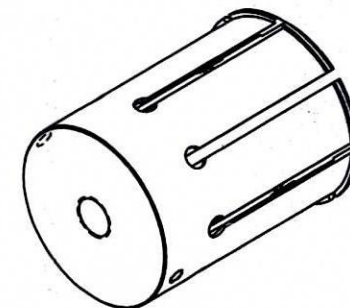
Change No:

Job No: 170254

2.425

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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			



DETAIL A
SCALE 2:1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170251 MLS
1801-12

(-1)

PULLER

DART AEROSPACE	
TITLE ENGINE/GEARBOX SEAL PULLER	
DWG NO. RBT18560-1	REV 4
MAT'L H13 HEAT TREAT RC 45-52 FINISH BLACK OXIDE SPEC DRAWN BY: COLE QA APPR: APPROVED: WEIL SCALE 2:3 DATE 5/2/2002 SHEET 2 OF 6	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ± 1/8 ANGLES ± 5° SURFACES = 125 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY	
USED ON MODEL	
SEE SHT 1	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																				
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																				
Large Fab ☐	Composite ☐	Supplier ☐																					
Date :	Step #:	QTY Effective :				MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition				Completed By																	
						Lead hand / Supervisor Approval Verification																	
						QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO039337

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No:	PO039337
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PO Date: 3/16/18

Due Date: 3/23/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, Chrisoula **Phone:**

Via: Ground

Pymt Terms: Net 30

Freight Terms:**Special Comments:**

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170254	RBT18560-1	Puller -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required ***NOTE***DO NOT SURFACE FINISH RBT560-1 EXPANDER FIXTURES, PLEASE ENSURE TO RETURN EXPANDER FIXTURES TO DART.	Firmed	3/23/18	7 pcs	0 pcs	7 pcs	\$17.14285710/pcs	\$120.00
Grand Total:										\$120.00

Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/23/18 11:11 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(007671-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

007671 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
27-Mar-2018		Aman	PO039337					
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT18560-11 Rev.	RBT18560-11 BLACK OXIDE FINISH MIL-C-13924C CLASS 1	OXIDE-BLACK CH	7	7	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.